

Date: Monday, 05/01/2009 9:50:41 AM
User: Julie Dawson










Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BUSHING
Job Number	: 44360		
Estimate Number	: 10308		
P.O. Number	:	Part Number	: D26173
This Issue	: 05/01/2009 S.O. No. :	Drawing Number	: D2617 REV D2
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 05/01/2009 Type : MACHINED PARTS	Drawing Revision	: D2
Previous Run	: 29991	Material	:
Written By	:	Due Date	: 31/01/2009 Qty: 30 Um: Each
Checked & Approved By	: <u>JLD 09.01.05</u>		
Comment	: Est G 04.07.14 Reformat; added step 5 KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6T0375W058	6061-T6 RD Tube .375 x.058W	
			
Comment: Qty.: 0.0765 f(s)/Unit Total : 2.2964 f(s) 6061-T6 Round Bar 1.5" Material : 6061-T6 (QQ-A-225/8 or QQ-A-200/8 or WW-T-700/6) Ø0.375" tubing x 0.058" wall (M6061T6T0.375W.058) Batch: <u>M110271</u> <u>ml 09/01/08</u> 30			
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
			
Comment: HARDINGE Turn as per Folio FA437 and Dwg D2617 <u>ml 09/01/08</u> 30			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>ml 09/01/08</u> 30			
4.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK <u>SD 09/01/09</u> 30			
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
			
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr break all unmarked sharp edges 0.005 to 0.010 <u>ml 09/01/09</u> 30			

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: BUSHING

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(30)

Comment: Acid etch and Alodine as per QSI 005 4.1

09/01/12

7.0

QC5

INSPECT WORK TO CURRENT STEP



cont'd

Comment: INSPECT WORK TO CURRENT STEP

09/01/12

(30)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST-39

09/01/12

9.0

QC21

FINAL INSPECTION/W/O RELEASE



09/01/14

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-01-12

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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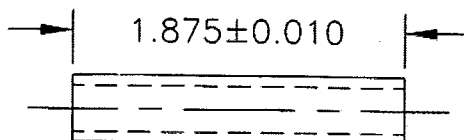
NOTE: Date & initial all entries



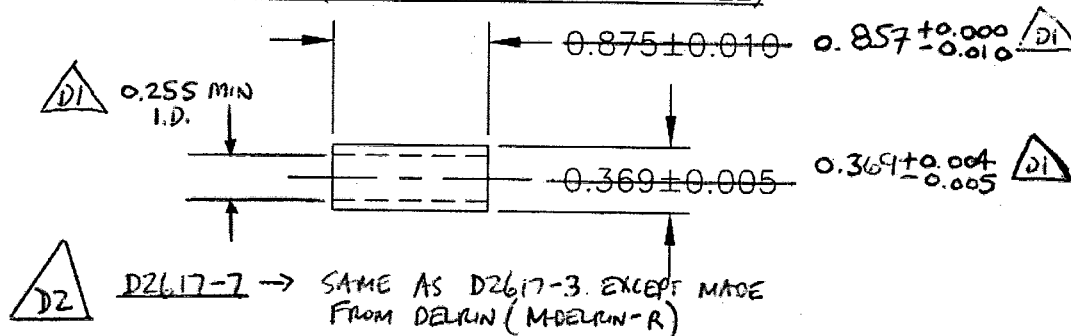
DESIGN	BW	DRAWN BY	UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO. D2617	REV. D SHEET 1 OF 1
DATE 01.07.04				TITLE BUSHING SCALE 1:1	

D2	04.04.10	UP	ADD D2617-7	A	96.10.08	NEW ISSUE
				B	97.05.08	.875 WAS 1.125
				C	97.06.04	0.369 DIA WAS 0.375
				D	01.07.04	ADD MAT'L SPEC AND TOL./DIM. NOTE
				D1	UP-#	04.07.12 CORRECT TOLERANCE (NCR 779)

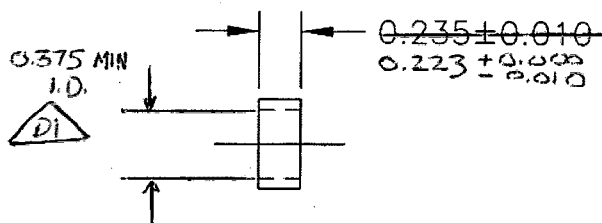
D2617-1 (0.375 OD x 0.058 WALL)



D2617-3 (0.375 OD x 0.058 WALL)



D2617-5 (0.500 OD x 0.058 WALL)



RELEASED
01.07.05

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 41360

NOTES:

- 1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)
OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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